

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76936

Thursday, November 24, 2011 9:49:17 AM

76936

Page 2

Item ID: D4510-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Pilot Panel

Stop ***NS2***

Start Date: 11/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130	NC BRAKE								
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location:	0.00							
150									
Packaging	Memo	0.00							
Packaging									

[Handwritten signature]
1 BR 11-11-08.

[Handwritten signature]
1 x *[Handwritten signature]*

Ship Eagle

[Handwritten signature]
1 - *[Handwritten signature]*

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76936***76936***

Page 3

Thursday, November 24, 2011 9:49:17 AM

Item ID: D4510-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Pilot Panel

Stop ***NS2***

Start Date: 11/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

11/11/28 [Signature]
MF
11-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 9:49:17 AM

Page 1

Work Order ID: 76936

Parent Item: D4510-3

Parent Item Name: Pilot Panel

Start Date: 11/24/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.08 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	87.2400	2.3344	2.4572632			
6061-T6 .125 Sheet													

FB11-11-24

Location

Loc Qty

Loc Code

MAT009

7.4

119513

7.4

MAT021

79.84

113608

65.35

118217

14.49

119513

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76936
Description: PILOT PANEL	Part Number: D4510-3
Inspection Dwg: D4510-3 Rev: 4	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.20	+ .004 - .001	1.24	2		V	1801
Ø 1.70	+ .005 - .001	1.73	2		V	
Ø 2.50	+ .005 - .001	2.50	2		V	
Ø 2.300	+ .012 - .001	2.341	2		V	
Ø 2.828	+ .012 - .001	2.828	2		V	
Ø 3.170	+ .012 - .001	3.171	2		V	
Ø 1.500	+ .006 - .001	1.501	2		V	
1.50	± .030	1.500	2		V	
1.19	± .030	1.193	2		V	
.70	± .030	.697	2		V	
5.26	± .030	5.192	2		V	
4.20	± .030	4.263	2		V	
4.95	± .030	4.945	2		V	
1.03	± .030	1.026	2		V	
1.35	± .030	1.352	2		V	
2.85	± .030	2.852	2		V	
4.50	± .030	4.563	2		V	
4.82	± .030	4.822	2		V	
6.32	± .030	6.326	2		V	
8.46	± .030	8.468	2		Flow 302	
9.47	± .030	9.474	2		P	
10.48	± .030	10.489	2		P	
16.71	± .030	16.71	2		T 1801	

Measured by: B	Audited by: J	Prototype Approval:
Date: 11-11-29	Date: 11/11/25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 76936
Description: PILOT PANEL		Part Number: D4510-3
Inspection Dwg: D4510-3 Rev: A		Page 1 of 1

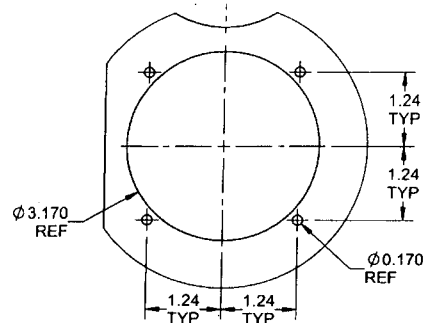
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

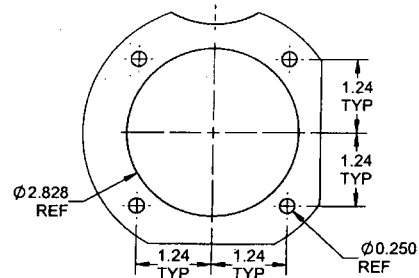
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.97 \pm	.030	16.97	2		T BO1	
19.28 \pm	.030	19.28	2		T	
1.42 \pm	.030	1.426	2		V BO2	
1.95 \pm	.030	1.95	2		V	
7.34 \pm	.030	7.349	2		V	
13.90 \pm	.030	13.90	2		T	
14.24 \pm	.030	14.24	2		T	
15.49 \pm	.030	15.49	2		T	
19.92 \pm	.030	19.92	2		T	
21.69 \pm	.030	21.69	2		T	
1.88 \pm	.030	1.891	2		V	
1.90 \pm	.030	1.901	2		V	
5.12 \pm	.030	5.115	2		V	
6.87 \pm	.030	6.867	2		V	
8.49 \pm	.030	8.486	2		Prox 2	
10.37 \pm	.030	10.367	2		P	
12.43 \pm	.030	12.43	2		T	
2.03 \pm	.030	2.034	2		P	
2.48 \pm	.030	2.490	2		P	
6.93 \pm	.030	6.937	2		P	
8.08 \pm	.030	8.078	2		P	
11.65 \pm	.030	11.65	2		T	
13.48 \pm	.030	13.48	2		T	

Measured by: RB	Audited by: J	Prototype Approval:
Date: 11-11-08	Date: 4/11/05	Date:

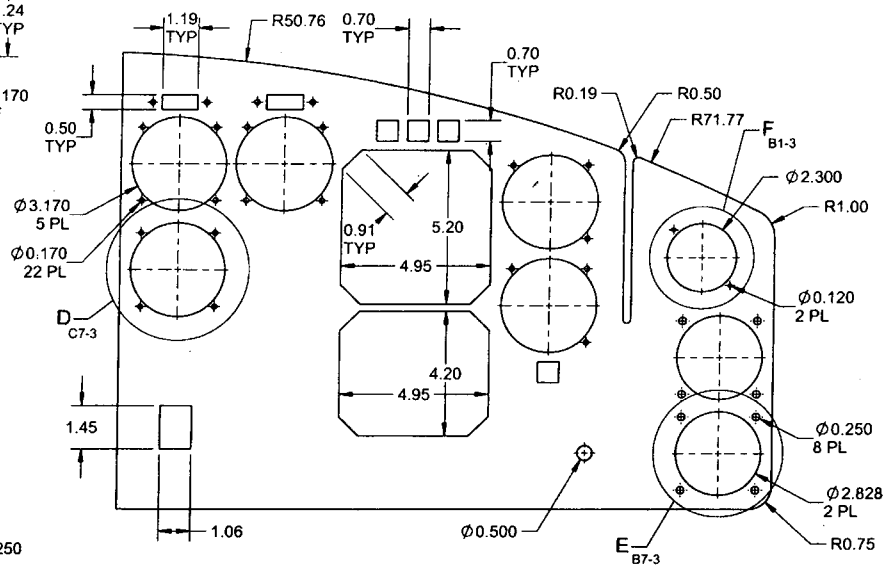
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



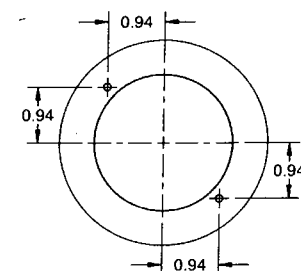
DETAIL D
SCALE 0.5X C6-3



DETAIL E
SCALE 0.5X B4-3



D4510-3 PILOT PANEL



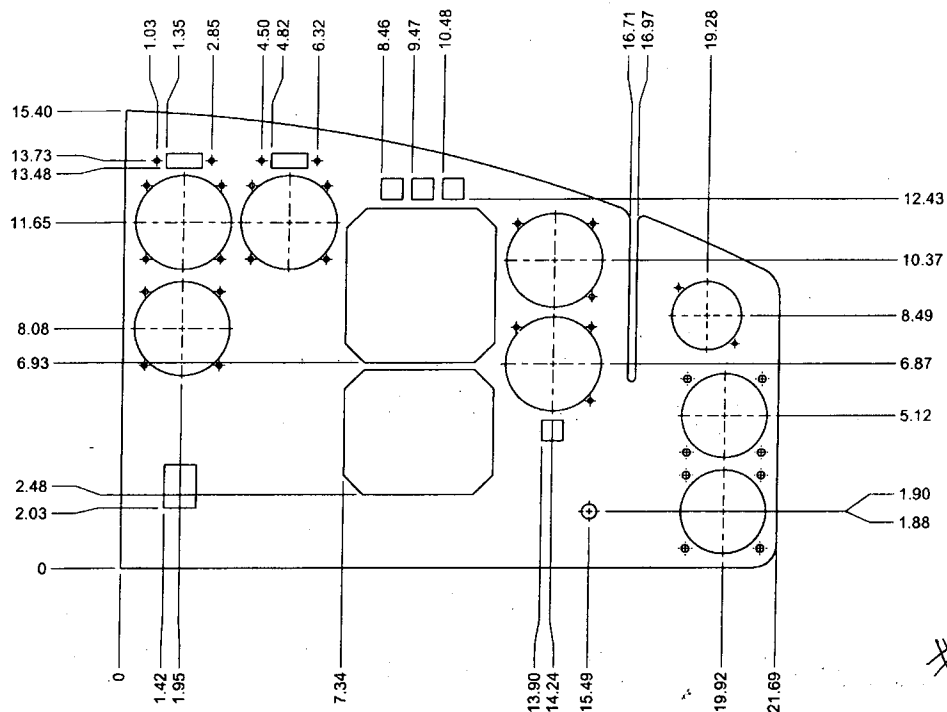
DETAIL F
SCALE 0.5X C4-3

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
OR
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4510	SHEET 3 OF 4
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#76936 RELEASED
2011-11-04

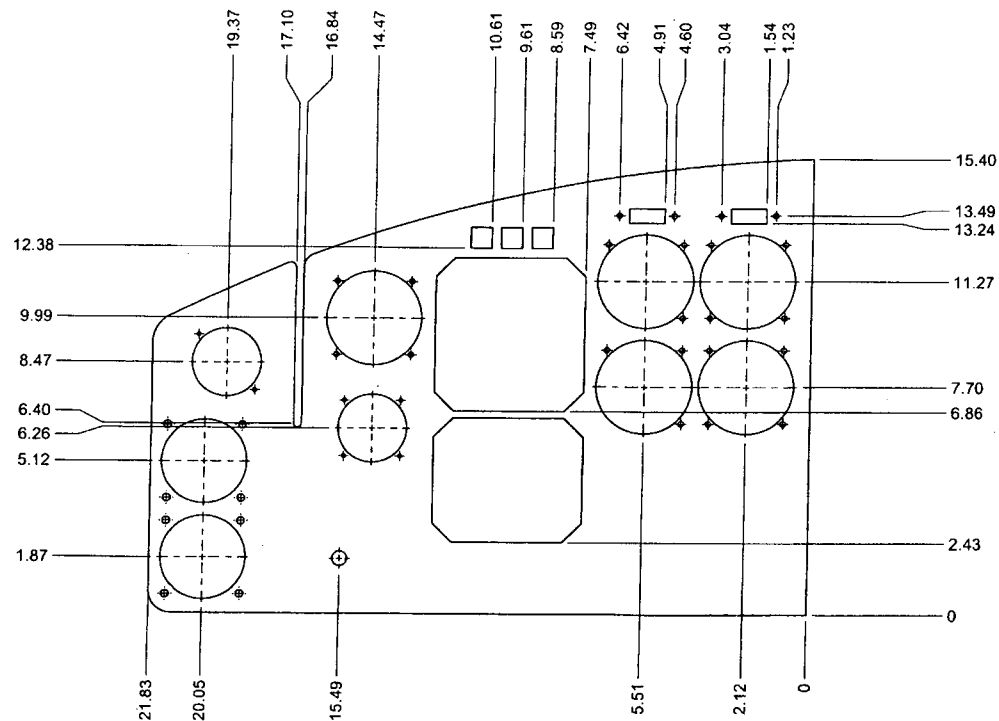


D4510-3 PILOT PANEL
AUXILIARY VIEW

76936

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2011-11-04

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MFG. APPR.		D4510	SHEET 4 OF 4
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D4510-1 COPILOT PANEL
AUXILIARY VIEW

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